






Work Order ID 61800



September 7, 2010 10:12:58 AM



Page 1

Item ID: D3975-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Gas Cylinder
Start Date: 9/03/10 Start Qty: 8.00  Cust Item ID:
Required Date: 9/14/10 Req'd Qty: 8.00  Customer:

Reference:

Approvals: Process Plan: CX Date: 10/9/7 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3975	B
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100  PURCHASING 0.00

Purchasing Memo 0.00

Purchasing Issue P/O: 12515
Possible Supplier: Clippard Instrument Laboratory
Part Number: Heavy Duty Brass Cylinder 7DIH
Material release note is required


CX 10/9/7 (8)

110  Receive & Inspect for Damage & Mat'l Certs 0.00

Packaging Memo 0.00

Packaging Ensure material certification is attached

C 10/9/22 (8)

120  QC6- Inspect dimensions to drawing 0.00

QC Memo 0.00

Quality Control

8/10/09/23

(78)

Work Order ID 61800

Friday, September 03, 2010 1:42:02 PM



Page 2

Item ID: D3975-1

Accept



Setup Start



Revision ID:

Item Name: Gas Cylinder

Stop



Start Date: 9/3/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: *10/2/03*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Memo

0.00

Small Fab

Identify with vibrating stylus as per dwg D3975

EP 10/09/27 *(8)*

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sc 10/09/28

(8)

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify as per dwg and Stock
Location: *61799*
61798

Sc 10/09/28

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61800

Friday, September 03, 2010 1:42:02 PM



Page 3

Item ID: D3975-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Gas Cylinder

Start Date: 9/3/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/28 JG

N10-9-25
(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, September 03, 2010 1:42:06 PM

Page 1

Work Order ID: 61800



Parent Item: D3975-1



Parent Item Name: Gas Cylinder


Start Date: 9/3/2010

Required Date: 9/14/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.05.27 as per ECN10-548 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
7D-1-H  Clippard Brass Cylinder		Purchased	No			110	Each	0.0000	1	8			



Copy 10/27/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

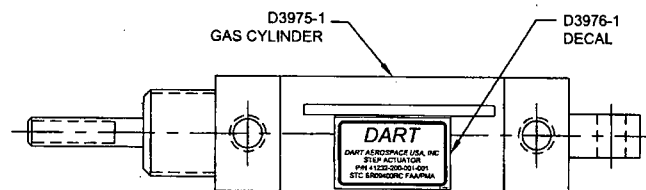
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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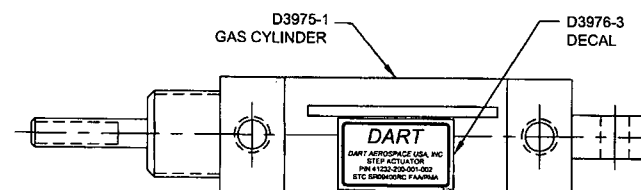
ITEM No.	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
1	X		D3975-041	GAS CYLINDER ASSEMBLY (LH)
2		X	D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3 [△]	DECAL

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4500
R10-903



D3975-041 GAS CYLINDER ASSEMBLY



D3975-042 GAS CYLINDER ASSEMBLY

RELEASED
2010-05-20

B	CORRECTED TYPO: D3976-3 WAS D3975-3 (ZN D7-1).	MB	10.04.13
A	NEW ISSUE	AJS	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.13		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
REV. B
SHEET 1 OF 2
TITLE
GAS CYLINDER ASSEMBLY
SCALE
NTS

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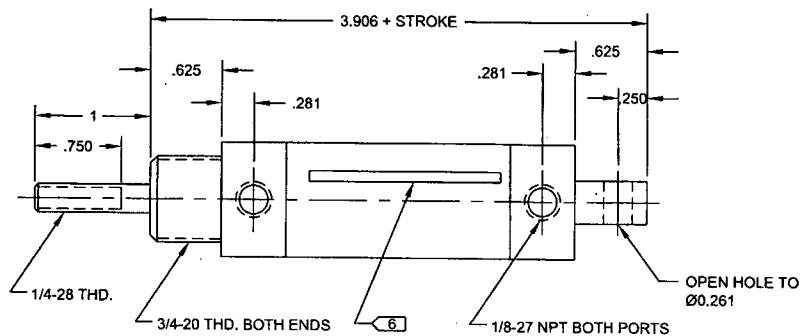
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D3975-1 BRASS CYLINDER

NOTES:

- 1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC, CINCINNATI, OH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs APPROX
- 2) BORE: 0.875 INCHES
- 3) ROD: ROTATING.
- 4) 7D1H CONFIGURED WITH HYD. FLUID SEALS.
- 5) TEMPERATURE RANGE: 30° F TO 230° F.
- 6) MOUNT: UNIVERSAL MOUNT.
- 7) ACTION: DOUBLE ACTING.
- 8) STROKE: 1.000 INCH.
- 9) POWER FACTOR: 0.6 SQ. IN.
- 10) PORTS: 1/8 NPT.
- 11) ROD DIAMETER: 0.25 INCHES.
- 12) SINTERED BRONZE ROD BUSHING.
- 13) PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

RELEASED
2010-05-20

DESIGN	445	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. B
MFG. APPR.	18	D3975	SHEET 2 OF 2
APPROVED	18	TITLE	SCALE
DE APPR.	18	GAS CYLINDER ASSEMBLY	NTS
DATE	10.04.13	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR CONVEYANCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO12515**

Purchase Order Date 9/07/10
PO Print Date 9/07/10

Page Number 1 of 1

Order From :

VC-ROY001

Contact Name
Vendor Phone
Vendor Fax
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms COD
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
9/10/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	7D-1-H	Clippard Brass Cylinder	9/16/10 Yes	8.00 Each	FedEx PI ppd	\$100.9700	\$807.76

Special Inst: AS PER DWG D3975 REV. B
B61800
WAINBEE P/N: 7DIH

PO Total: \$807.76

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

PO Instructions: WAINBEE
VISA ACCT: 4516 0500 0053 0448 EXP DATE:05/14

CL

u

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 9/07/10



WAINBEE LIMITED
215 BOUL BRUNSWICK
POINTE CLAIRE, QC H9R 4R7
Phone: 514-697-8810 Fax: 514-697-3070

Packing List

CUSTOMER P/O NUMBER	
PO12515	
RELEASE # 11226587-1	
DATE	09/21/10 13:05:44

127404
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
613-632-3336

SHIP TO
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

ORDER NUMBER 11226587	ORDER DATE 09/07/10	SHIP DATE 09/21/10	WRITTEN BY Frederic Lavoie		CONTACT CHANTAL LAVOIE			
CUSTOMER P/O NUMBER PO12515								
JOB #								
RELEASE # E								
PRODUCT / DESCRIPTION				QUANTITY OPEN	U/M	QUANTITY SHIPPED	QUANTITY BACKORDERED	PRICE / EXTENSION
7D-1-H CLIPPARD BRASS CYLINDER				8	EA	8	0	100.970
								807.76

8 10/01/23

Wainbee's Standard Terms and Conditions Apply

Returned Goods Not Accepted Without Prior Authorization.

Claims For Shortages Or Losses Are Not Accepted 10 Days After Shipment.